



SUPERMONEL

NON FERROUS (Ni Alloys)

AWS A/SFA 5.11 ENiCu-7

CLASSIFICATION:

ISO 14172

E Ni 4060 (NiCu30Mn3Ti)

KEY FEATURES:

- Monel electrode
- Low iron in the deposit exhibit maximum corrosion resistance
- Medium penetration weld
- Easily machinable deposit in as welded and stress relieved condition
- Passes 180° bend test on monel alloy 400 plate

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding monel to itself, to stainless steels or carbon steels
- Overlaying on steel to obtain a corrosion resistant surface
- Welding of ASTM B127/163/164/165
- Refineries, Off shore, Foundries, Chemical and Fertilizer plants
- Heat exchanger, Pressure vessel and Column manufacturing units
- Food, Pumps & Valves manufacturing units


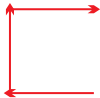
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Al	Ti
0.02	3.1	1.0	1.0	65	0.04	0.4

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	535	34
Specification		480 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	45 - 70	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	80 - 100		
4.0 x 350	90 - 130		

Available in packing of 10 kg box containing 10 plastic cartons of 1 kg each.